

SLIT

Dart Aerospace Ltd.

Friday, 5/2/2007 8:38:45 AM

Item: 1000000000

# Process Sheet

POSITIVE RECALL

Part Number : 100-DAR001 Dart Helicopters Services  
Drawing Name : ARM  
Effective : 07-06-03 AUTH : CP  
Released : 07-06-03 DATE : CP  
Part Number : D3560043  
Drawing Number : D3560 REV B  
Project Number : N/A  
Drawing Revision : 5  
Material : N/A  
Due Date : 5/5/2007 Qty: 10  
S.O. No. : N/A  
Type : SMALL MED FAB  
Est. Rev. A New Issue 07 05 24 EC

Part Number : D3560043  
Drawing Number : D3560 REV B  
Project Number : N/A  
Drawing Revision : 5  
Material : N/A  
Due Date : 5/5/2007 Qty: 10



Machine Or Operation:

Description:

100-DAR001

600-10 Bar 50" x 5.00"



1 3598 t(s)/Unit Total: 40.7925 t(s)

600-10 Bar 0.50" x 5.00"

100-DAR001 1004598 X 7

10

BAND SAW



BAND SAW

100-DAR001 15.500" long

HAAS CNC VERTICAL MACHINING #1



HAAS CNC VERTICAL MACHINING #1

100-DAR001 as per Folio FA695 Rev. 1 & Dwg D3560 Rev. 1

100-DAR001 0.198" hole on manual mill as per dwg D3560

100-DAR001 De-burr per dwg D3560

INSPECT PARTS AS THEY COME OFF MACHINE



INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



SECOND CHECK

100-DAR001 07/06/05

10





# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Part Number: 31448

Part Number: D05500-03

QTY: 1



Step #

Machine Or Operation:

Description:

1.0

PLATE



QTY: 10000 Each(s)/Unit Total 30.0000 Each(s)

PLATE 3.52661

FE 07-06-06 (5)

FINISHING

LARGE FABRICATION RESOURCE #1



QTY: 10000 LARGE FABRICATION RESOURCE #1

Weld assembly as per dwg 0055

INSPECT WORK TO CURRENT STEP

FE 07-06-07 (5)



QTY: 10000 INSPECT WORK TO CURRENT STEP

VISUAL WELDING INSPECTION



QTY: 10000 VISUAL WELDING INSPECTION

FINISHING

HAND FINISHING RESOURCE #1

FE 07-06-07 (5)



QTY: 10000 HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

POWDER COATING

POWDER COATING



QTY: 10000 POWDER COATING

NO POWDER COAT.

SEE W/D CHANGE

Powder Coat White Gloss (Ref. 4.3 5.1) as per QSI 005 4.3

INSPECT POWDER COAT/CHEMICAL CONVERSION



QTY: 10000 INSPECT POWDER COAT/CHEMICAL CONVERSION

PACKAGING

PACKAGING RESOURCE #1

SB 07/04/07 (5)



QTY: 10000 PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/04/07 (5)



Date: Friday, 5/26/2007 8:36:45 AM  
Ser: Kim Johnston

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AR11

Job Number: 33540

Part Number: C35500-03

Job Number: 

Seq #: Machine Or Operation:

Description:

147 0001

FINAL INSPECTION/W/O RELEASE





(15)

207106/05

u 07-06-05

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



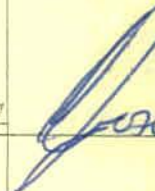

POSITIVE RECALL

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED u DATE 07-06-05





W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
<del>07.06.05</del> 07/06/12	<del>12.5</del> 12.5	<del>PRESS FIT QTY(1) D2800 AFTER POWDER COAT</del> <del>SEE ATTACHED DS EMAIL</del> Press fit D2800 Bushing 4/x <del>07/06/12</del> <sup>32752</sup>	FF	07/06/12		<del>07.06.05</del> per QS 042		
07.06.05	11	No powder coat, will be powder coated after assembly in D3562 STEP WELDMENT. REF ATTACHED DS EMAIL.				 07.06.06 per QS 042		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/12	3	- 1 part c-bore 507x250 deep is actually 205 deep is part acceptable			JL 07/06/12			

NOTE: Date & initial all entries





1) WELD PER QSI 004  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 006 4.3  
3) TOLERANCES ARE PER DART QSI 012 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES

RELEASE

07 05.07 1944

P	07-01-19	REUSION AS WELOMEM), ADD POCKETS.
A	06-09-29	NEN ISSUE
Q	07-01-19	Q
R	07-01-19	R
S	07-01-19	S
T	07-01-19	T
U	07-01-19	U
V	07-01-19	V
W	07-01-19	W
X	07-01-19	X
Y	07-01-19	Y
Z	07-01-19	Z



RELEASER

SECTION C-C  
NEW ROTATED  
SCALE 1:1

03560-3 ARM (SHOWN), 03560-4 ARM (OPPOSITE)  
1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
GO-A-200/P OR GO-A-250/P, REF DART SPEC.  
2) FINISH: NONE  
3) TOLERANCES ARE PER DART 051-018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) DRAWING ALL SHARP CORNERS 0.005 TO 0.010

PROFESSIONAL  
0307-1171  
ANNALS OF THE  
SEE SECTION 1





Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]  
Sent: June 5, 2007 5:18 PM  
To: 'Chris Provencal'  
Subject: RE: D3562-041/-042

As we have discussed previously, this is acceptable as long as the Magnabond doesn't break down.

David

---

From: Chris Provencal [mailto:cprovencal@dartaero.com]  
Sent: Tuesday, June 05, 2007 11:00 AM  
To: David Shepherd (David Shepherd)  
Subject: D3562-041/-042

Chris

For the D3562-041/-042 step weldment, as discussed, they want to switch from Sikaflex to Magnabond, and powder coat after final assembly.

As part of this change, the D3560-XX arms won't be powder coated, and the D2808 Bushing won't be assembled until after final assembly of the step weldment.

Since this is the first time trying this, we will ensure that the steps are checked after powdercoating in case the Magnabond does anything unexpected (eg. bubbling). If we see anything suspect, we will assemble them the old way.

Is this acceptable.

Chris

No virus found in this incoming message.  
Scanned by AVG Free Edition.  
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

No virus found in this outgoing message.  
Scanned by AVG Free Edition.  
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM









